

Work Order ID 67050

Friday, March 04, 2011 11:45:50 AM



Page 1

Item ID: D205-634-041

Accept



Setup Start



Revision ID:

Item Name: Replacement Skidtube

Stop



Start Date: 3/4/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 3/23/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

H

Date: *11-03-4*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2580

Rev.D DEO-D1

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy D205-634 bluefile & type labels per PPP D205-634-041 CHG003

8/10/03/68

CK 11/03/28

110

0.00



BENDING MACHINE - SKIDTUBES

CNC Bend 1

Memo

0.00

CNC Delta 100 Bender

1-Bend as per program D2580.C on CNC Bender and Folio 16

2-Cut tubes as per Dwg. D2580

3- scribe batch# in aft end of tube

1 @ BE 11/03/21

B67050

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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120

0.00



Skidtubes

Memo

0.00

Skidtubes

1- Deburr ends and remove bending marks

2- Prepare tube for swaging as per QSI 002

1
11/03/21

130

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

11-3-21

W/O:		WORK ORDER CHANGES					
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

140

0.00



Skidtubes

Skidtubes

Memo

0.00

1-Weld step D2576 as per Dwg. D2580 and QSI004
A/R□□□ Aluminum Rod

M116377

BE 11/03/22

2-Grind welds on step as per Dwg D2580

3-Insert D4202-1 spacer, swage as per QSI002 and trim/ grind flush per QSI002
and dwg. Hold x-bolt with DT9701 Use tube expander 1/2 x17G to start
expansion and finish with 1/2 x 18G to achieve dwg dimension.4-Drill holes for wearplates using DT 8217 & DT8937 Open holes to 19/64",
adjust stopper not to hit web. Debur

6-Drill pilot holes for aft cap using DT 8215 Open holes to 0.208". Debur

7-Drill pilot holes for Tow ring using DT8091, open to .640" and Debur

BE 11/03/22

150

QC10- Inspect visual per QSI004- ground welds

0.00



QC

Memo

0.00

Du 1/03/23

Quality Control

W/O:		WORK ORDER CHANGES					
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Customer:

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00							
				8/11/03/23					
170 HandFinish Hand Finishing	Pressure Wash per QSI005 4.3 Memo Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch and leave fwd cap out of solution.	0.00 0.00							
						1		BK 11-3-23	
180 Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum Memo START TIME: 3:30 OVEN TEMPERATURE: 325 FINISH TIME: 4:00	0.00 0.00							
						1		BK 11-3-23	

W/O:		WORK ORDER CHANGES					
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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

1 φ 24 4/103/25

11-03-28

①

W/O:		WORK ORDER CHANGES					
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Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

200

0.00



HandFinish

Memo

0.00

Hand Finishing

- 1-Install inserts & wearplates & Gaskets as per Dwg. D2580. Use a drop of Sikaflex on insert holes before installing wearplates
A/R ☐ ☐ ☐ Sikaflex-291 ☐ 11116040
Sikaflex expire date: 1109
- 2-Coat D2594-3 O' rings with Petroleum Jelly and install on D2594-1 plugs as per Dwg D2580
- 3-Inspect for foreign object per QSI 024
- 4-Install 2855 Aft Cap as per Dwg D2580 and seal Fwd Step & Aft Cap with Sikaflex. Clean excess adhesive
A/R ☐ ☐ ☐ Sikaflex-291 ☐ 11116040
Sikaflex expire date: 1109
- 5-Wing Walk as per Dwg D2580 and QSI 005 4.4
Batch: 11116040

1 0 11116040

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Cust Item ID:

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Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
210 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo Inspect Aft Cap, Fwd Step and Wing Walk of work to Current Step Inspect for Foreign objects per QSI 024	0.00 0.00							
220 Packaging Packaging	Packaging Memo Identify and pack for shipping as per PPPD205-634-041 Location: _____ PPP Rev:	0.00 0.00							
230 QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							

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Picklist Print

Friday, March 04, 2011 11:45:57 AM

Page 1
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Work Order ID: 67050

Parent Item: D205-634-041

Parent Item Name: Replacement Skidtube




Start Date: 3/4/2011

Required Date: 3/23/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:N 02.08.28 FP was QC5 in Step 27; Added QC5 to Step 30
KJ IPP Rev P 10.02.19
per PAR09-043 EC verified by:DD
IPP Rev. O 06.02.28 Added paperwork EC
IPP Rev:P 07-07-09 SS Wearplates & Gaskets JLM IPP Rev:Q
10.12.01 as per chg003 DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4202-1  Spacer		Manufactured	No			140	Each	240.0000	20	20			
<div> <div>Location</div> <div>Loc Qty</div> <div>Loc Code</div> </div>													
<div> <div>LG</div> <div>240</div> <div></div> </div>													
<div> <div>65529</div> <div>26</div> <div></div> </div>													
<div> <div>66121</div> <div>214</div> <div></div> </div>													
D2580-1  205 Skidtube bent detail		Manufactured	No			110	Each	11.0000	1	1			
<div> <div>Location</div> <div>Loc Qty</div> <div>Loc Code</div> </div>													
<div> <div>LG</div> <div>11</div> <div></div> </div>													
<div> <div>59856</div> <div>1</div> <div></div> </div>													
<div> <div>65509</div> <div>5</div> <div></div> </div>													
<div> <div>65510</div> <div>4</div> <div></div> </div>													
<div> <div>65511</div> <div>1</div> <div></div> </div>													
D2576-3  Step (maching detail)		Manufactured	No			140	Each	40.0000	1	1			
<div> <div>Location</div> <div>Loc Qty</div> <div>Loc Code</div> </div>													
<div> <div>LG</div> <div>40</div> <div></div> </div>													
<div> <div>52215</div> <div>40</div> <div></div> </div>													

BE11/03/22
867308 (20)

BE11/03/21
867075 (1)

BE11/03/22

W/O:		WORK ORDER CHANGES					
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Parent Item: D205-634-041

Parent Item Name: Replacement Skidtube

Start Date: 3/4/2011

Required Date: 3/23/2011

Start Qty: 1.00

Required Qty: 1.00

D2855

Manufactured No

200

Each

88.0000

1

1



Cap



ul 4/03/25

Location

Loc Qty

Loc Code

FP6

1

56613

1

fp7

15

65519

15

ST024

72

50513

1

50770

28

51539

2

53791

6

65569

35

x1

AN3-5A

Purchased No

200

Each

705.0000

2

2



Bolt



ul 4/03/25

Location

Loc Qty

Loc Code

ST350

705

115016

39

115371

500

116632

166

AN960JD10L

NAS1149D0332J

Purchased No

200

Each

4.0000

2

2



Washer



ul 4/03/25

Location

Loc Qty

Loc Code

ST335

4

11912

4

M117010

x2

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Shop Packet Print

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Parent Item: D205-634-041

Parent Item Name: Replacement Skidtube

Start Date: 3/4/2011

Required Date: 3/23/2011

Start Qty: 1.00

Required Qty: 1.00

ALS7-1032-130

Purchased

No

200

Each

1,604.000

50

50



Insert



1103/25

Location

Loc Qty

Loc Code

FP

21

115079

21

ST282

1583

111529

32

113238

17

115502

500

115581

34

116800

1000

X50

AN3C4A

Purchased

No

200

Each

2,476.000

50

50



BOLT



1103/25

Location

Loc Qty

Loc Code

ST350

2476

115300

25

116075

337

116704

414

116924

1200

117010

500

X50

AN960C10L

NAS1149C0332

Purchased

No

200

Each

61.0000

50

50

R



washer



1103/25

Location

Loc Qty

Loc Code

ST245

61

107534

59

108246

2

1116304

X50

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Parent Item Name: Replacement Skidtube

Start Date: 3/4/2011



Required Date: 3/23/2011

Start Qty: 1.00



Required Qty: 1.00

D3566-13 Manufactured No 200 Each 61.0000 1 1
Gasket   xl 11/03/25

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP011	36	
66550	36	<u>xl</u>
FP014	25	
64070	8	
66137	17	

D3566-5 Manufactured No 200 Each 40.0000 1 1
Gasket   xl 11/03/25

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP015	40	
63574	1	
65528	13	
66146	6	
66552	20	<u>xl</u>

D3566-1 Manufactured No 200 Each 62.0000 2 2
Gasket   xl 11/03/25

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP	20	
66548	20	
FP011	19	
65525	19	B67496
FP015	23	
57715	1	
66040	20	
66129	2	

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Parent Item: D205-634-041


Parent Item Name: Replacement Skidtube

Start Date: 3/4/2011

Required Date: 3/23/2011


Start Qty: 1.00

Required Qty: 1.00

D3564-11 Manufactured No 200 Each 19.0000 1 1

Wearshoe


Location Loc Qty Loc Code

FP019 19 B66154 xl
65159 5
66554 14

D3564-13 Manufactured No 200 Each 48.0000 1 1

Wearshoe

Location Loc Qty Loc Code

FP16 25
65522 7
66549 18 xl
FP17 23
59660 1
66136 22

D3564-9 Manufactured No 200 Each 20.0000 1 1

Wearshoe

Location Loc Qty Loc Code

FP 1
55334 1
FP019 18
66153 18 xl
FP19 1
62238 1

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Start Date: 3/4/2011

Required Date: 3/23/2011

Start Qty: 1.00

Required Qty: 1.00

D3564-5

Manufactured No

200

Each

44.0000

1

1



Wearshoe



4/10/25

Location

Loc Qty

Loc Code

FG

1

34806

1

FP19

24

57525

1

58709

1

66551

22

X1

FP-19

19

63575

1

65523

3

66148

15

D2594-3

Manufactured No

200

Each

967.0000

16

16



O-Ring, 205 Skidtube



4/10/25

Location

Loc Qty

Loc Code

FP

543

55546

19

58191

12

59358

12

65518

500

fpa

424

X16

61762

424

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Start Date: 3/4/2011

Required Date: 3/23/2011

Start Qty: 1.00

Required Qty: 1.00

D2594-1

Manufactured No

200

Each

696.0000

16

16



Plug, 205 Skidtube



16

Location

Loc Qty

Loc Code

FP

483

42807

112

55002

71

66122

300

x 16

FP14

213

58434

15

65512

133

65980

65

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2580	REV. D SHEET 1 OF 3
DATE 07.02.27		TITLE 205 SKIDTUBE ASSEMBLY	SCALE NTS
A	96.09.16	NEW ISSUE	
B	96.12.02	AS MANUFACTURED	
C	98.08.26	REDRAWN, INCLUDED DEO 9094/9097	
D	07.02.27	CHANGE TO SS WEARPLATES AND GASKETS, INCLUDE DEO 9124/9183	

RELEASED
07.06.28 *[Signature]*

DEO ATTACHED

QTY -041	QTY -045	Part Number	Description
X		D2580-041	SKIDTUBE ASSEMBLY
	X	D2580-045	SKIDTUBE ASSEMBLY
1	1	D2500-1-190	EXTRUSION
1	1	D2576-3	STEP
20	24	D2579	CROSS BOLT SPACER
16	16	D2594-1	PLUG
16	16	D2594-3	O-RING
1	1	D2596	205 WEB
1	1	D2855	AFT CAP
1	1	D3564-5	WEARSHOE
1	1	D3564-9	WEARSHOE
1	1	D3564-11	WEARSHOE
1	1	D3564-13	WEARSHOE
2	2	D3566-1	GASKET
1	1	D3566-5	GASKET
1	1	D3566-13	GASKET
50	50	ALS7-1032-130 or AKS7-1032-130 or AKS4-1032-130 or AELS-1032-130	INSERT
50	50	AN3C4A	BOLT
2	2	AN3-5A	BOLT
50	50	AN960C10L	WASHER
2	2	AN960JD10L	WASHER

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RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *67050*
PL11-03-4

GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) INSERT D2596 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP.
- 4) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- 5) USE DART DRILL TEMPLATE TD2577-205 TO LOCATE AND DRILL Ø0.297 HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTION D-D (50 PLACES) AFTER FINISH. INSTALL AN3C4A BOLTS AND AN960C10L WASHERS WITH SIKAFLEX-241/-291.
- 6) WELDING TO BE DONE PER DART QSI 004.
- 7) FINISH:
SEE NOTES ON
PAGE 2 FOR D2580-041 AND
PAGE 3 FOR D2580-045
- 8) INSERT D2594-1 PLUG C/W D2594-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (16 PLACES).

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

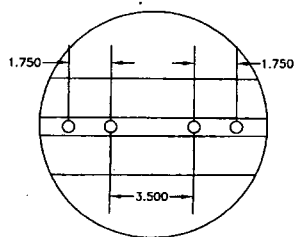
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

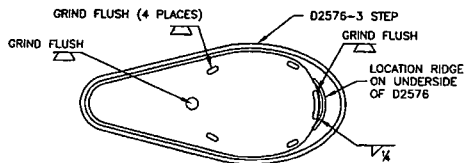
NOTE: Date & initial all entries

DETAIL A
SCALE 5:24

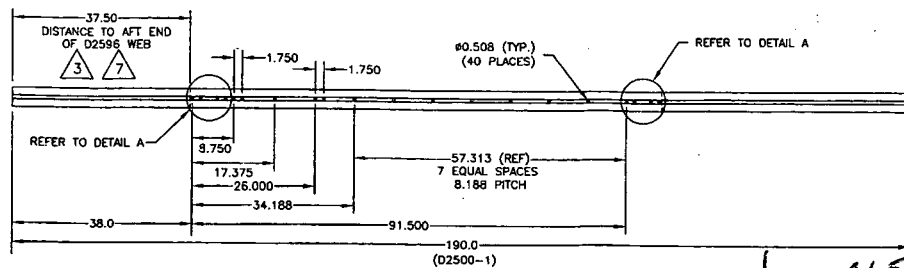


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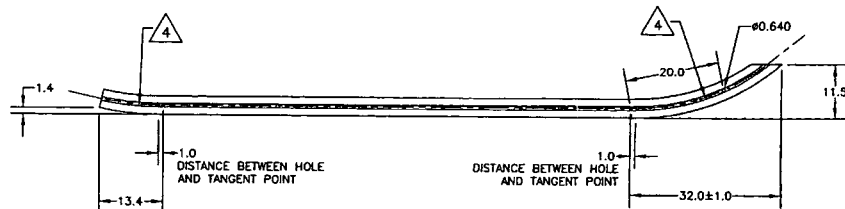
DETAIL B
SCALE 5:24



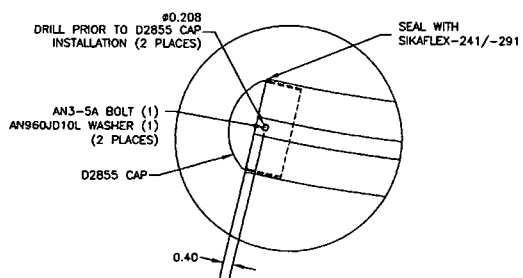
D2580-1 DRILLING DETAIL



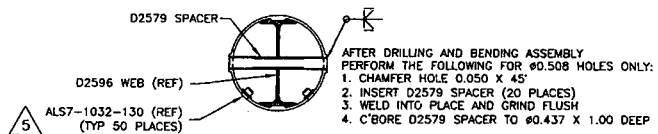
D2580-1 BENDING AND CUTTING DETAIL



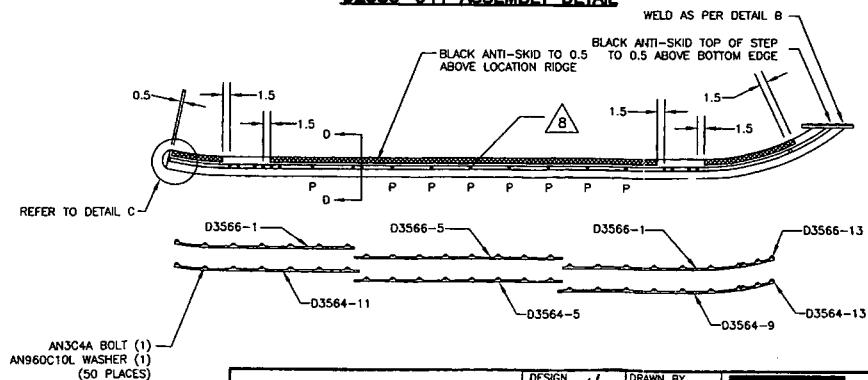
DETAIL C
SCALE 5:24



SECTION D-D
SCALE 5:24



D2580-041 ASSEMBLY DETAIL



D2580-041 NOTES

- i) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB POWDER COAT ASSEMBLY GLOSS WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3 BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4

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DATE _____

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DART AEROSPACE LTD.
HAWKESBURY, ONTARIO, CANADA

DRAWING NO.	REV. D
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D2580 SHEET 2 OF 3

TITLE	SCALE
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205 SKIDTUBE ASSEMBLY 1:24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

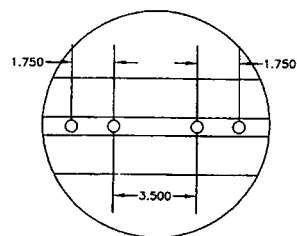
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

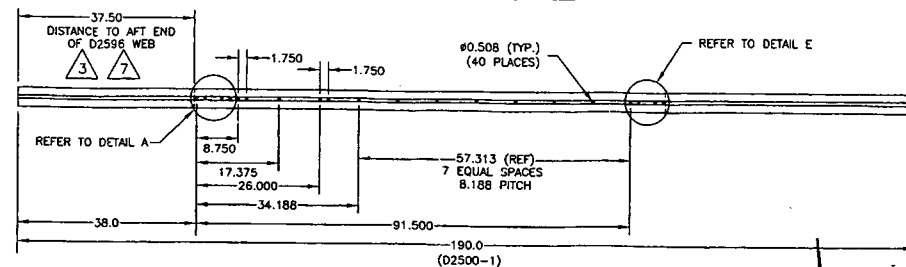
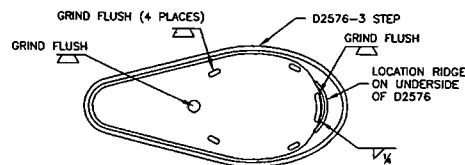
NOTE: Date & initial all entries

D2580-1 DRILLING DETAIL



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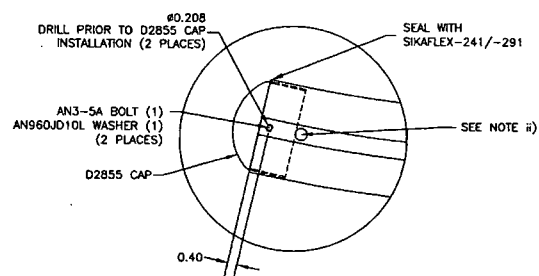
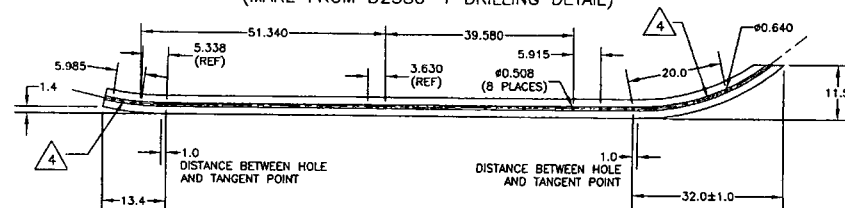
D2580-5 BENDING AND CUTTING DETAIL
(MAKE FROM D2580-1 DRILLING DETAIL)



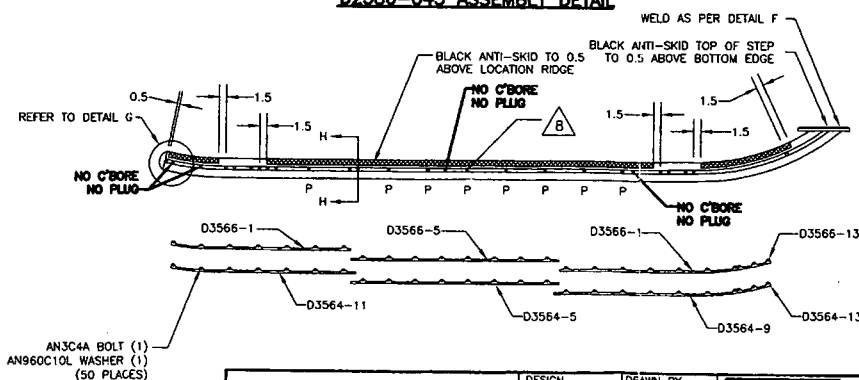
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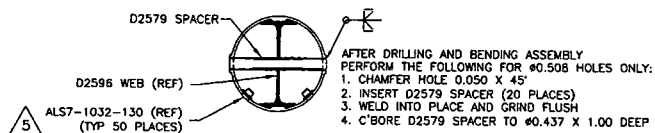
D2580-045 ASSEMBLY DETAIL



D2580-045 ASSEMBLY DETAIL



SECTION H-H
SCALE 5:24



D2580-045 NOTES

- i) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB POWDER COAT ENTIRE ASSEMBLY GREEN (REF. 4.3.5.8) PER DART QSI 005 4.3 BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4
- ii) IT IS ACCEPTABLE TO GRIND A RELIEF IN THE D2855 AFT CAP TO PREVENT INTERFERENCE WITH THE SPACER AT THIS LOCATION

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DART AEROSPACE LTD.
HAMPSHIRE, ONTARIO, CANADA

DRAWING NO.

DRAWING NO.
D2580

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REV. 0
PAGE 2 OF 2

SHEET 3 OF 3

SCALE

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DRAWING NO. D2580	TITLE 205 SKIDTUBE ASSEMBLY	REV. D	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D2580-D-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>UP</i>	CHECKED <i>L</i>	MFG. APPR. <i>B</i>	APPROVED <i>MP</i>		DE APPR. <i>#</i>		
DATE 10.09.22	DATE 10.11.04	DATE 10.11.04	DATE 10/11/04		DATE 10.11.04		

PURPOSE:

CHANGE ALL WELDED CROSSBOLT SPACERS TO SWAGED SPACERS

CHANGE:

PARTS LIST IS AMENDED AS FOLLOWS:

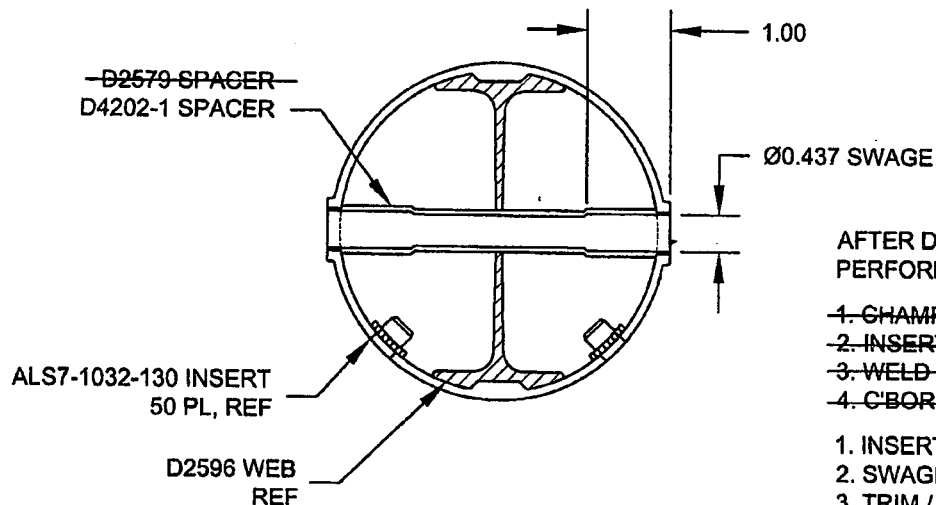
WAS

QTY	QTY	PART NUMBER	DESCRIPTION
-041	-045		
20	24	D2579	CROSS BOLT SPACER

IS

20	24	D4202-1	SPACER
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SECTION D-D & SECTION H-H ARE AMENDED AS FOLLOWS:



SECTION D-D
NOT TO SCALE

SECTION H-H
NOT TO SCALE

RELEASED
2010-11-18
MP

AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.508 HOLES ONLY:

1. CHAMFER HOLE 0.050 X 45°
2. INSERT D2579 SPACER (20 PLACES)
3. WELD INTO PLACE AND GRIND FLUSH
4. C-BORE D2579 SPACER TO Ø0.437 X 1.00 DEEP

1. INSERT D4202-1 SPACER, 20 PL (-041) OR 24 PL (-045)
2. SWAGE TO Ø0.437 X 1.00 DEEP PER QSI 002
3. TRIM / GRIND FLUSH PER QSI 002

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries